



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3065-7
Job Sheet 170515



Part No: D3065-7

Job Qty: 40 ea

Part Name: Step Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 1/26/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	1/25/18	1/25/18	0.00	0.00	Start Up Waterjet		DL 18/01/19
100	Waterjet	40 pcs	1/25/18	1/25/18	0.00	1.47	Waterjet1		DL 18/01/19
120	QC	40 pcs	1/25/18	1/25/18	0.00	0.00	QC8		38
130	Small Fab	40 pcs	1/25/18	1/25/18	0.00	0.00			9-88
140	Brake NC	40 pcs	1/25/18	1/25/18	0.02	1.23	Brake NC 1		FF/KAS
150	QC	40 pcs	1/25/18	1/25/18	0.00	0.00	QC5		38
160	HandFinish	40 pcs	1/26/18	1/26/18	0.00	0.71	HandFinish1		2018/01/24 JSL
170	QC	40 pcs	1/26/18	1/26/18	0.00	0.00	QC7-2		
180	Packaging	40 pcs	1/26/18	1/26/18	0.00	0.00	Packaging3-1		
190	QC21-SA	40 Ea	1/26/18	1/26/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D3065

Descriptions: 130 - Deburr if necessary.

140 - Bend as per Dwg D3065

180 - LOCATION : GA

DAS
21
9-88

JAN 26 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.040	6	107	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Spacer	0.128inches	+ 0.005 - 0.000	0.133 0.128	
2	Step Spacer	0.865inches	± 0.005	0.870 0.860	
3	Step Spacer	4.522inches	± 0.010	4.532 4.512	
4	Step Spacer	0.250inches	± 0.010	0.260 0.240	
5	Step Spacer	2.093inches	± 0.010	2.103 2.083	
6	Step Spacer	3.936inches	± 0.005	3.941 3.931	
7	Step Spacer	4.186inches	± 0.010	4.196	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

			4.176
8	Step Spacer	1.250inches $\pm$ 0.005	1.255 1.245
9	Step Spacer	0.125inches $\pm$ 0.010	0.135 0.115
10	Step Spacer	Attribute	

Plex 1/16/18 4:50 PM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL: 1 613 632 - 5200 Email: sales@dartaero.com www.dartaerospace.com		T DEPARTMENT/PROCESS <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; text-align: center;"> ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier </td> <td style="width:50%; text-align: center;"> ☐ Engineering ☐ Quality ☐ Other </td> </tr> </table>		☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier	☐ Engineering ☐ Quality ☐ Other																																																				
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